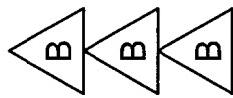


QTY	QTY	Part Number	Description
-041	-043	D2906-041	SKIDTUBE ASSEMBLY
X	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1	1	D2926-1	WEB
1	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	1	D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-15	GASKET
50	44	ALS7-1032-130	INSERT
		or AKS7-1032-130	
		or AKS4-1032-130	
		or ALS4-1032-130	
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

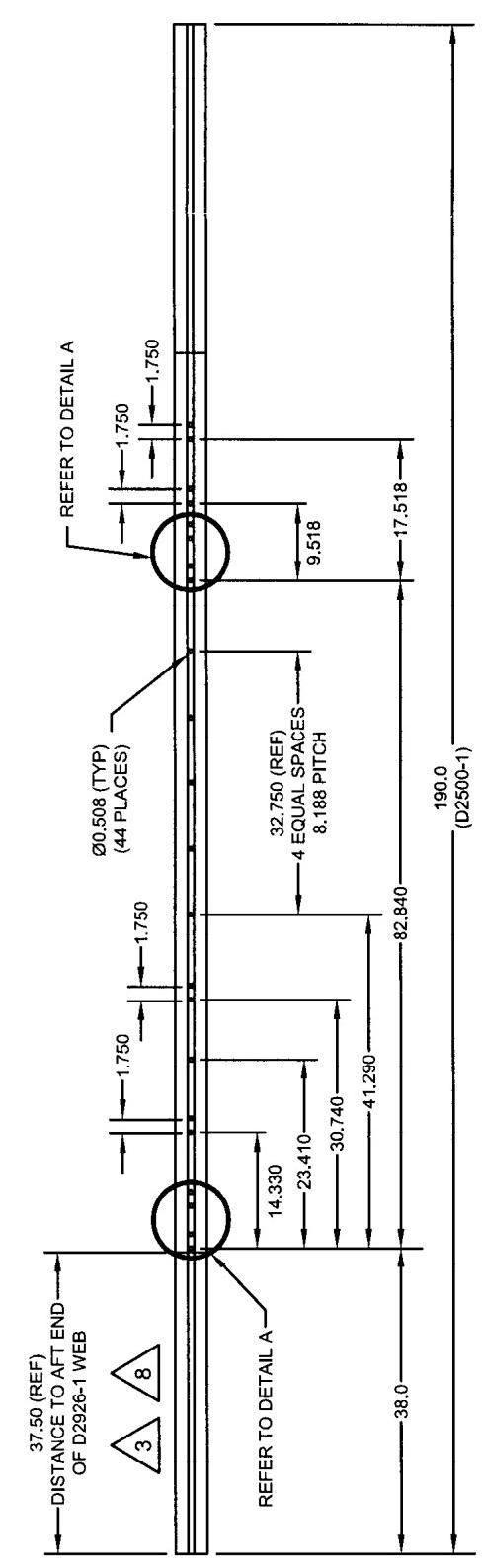


GENERAL NOTES:

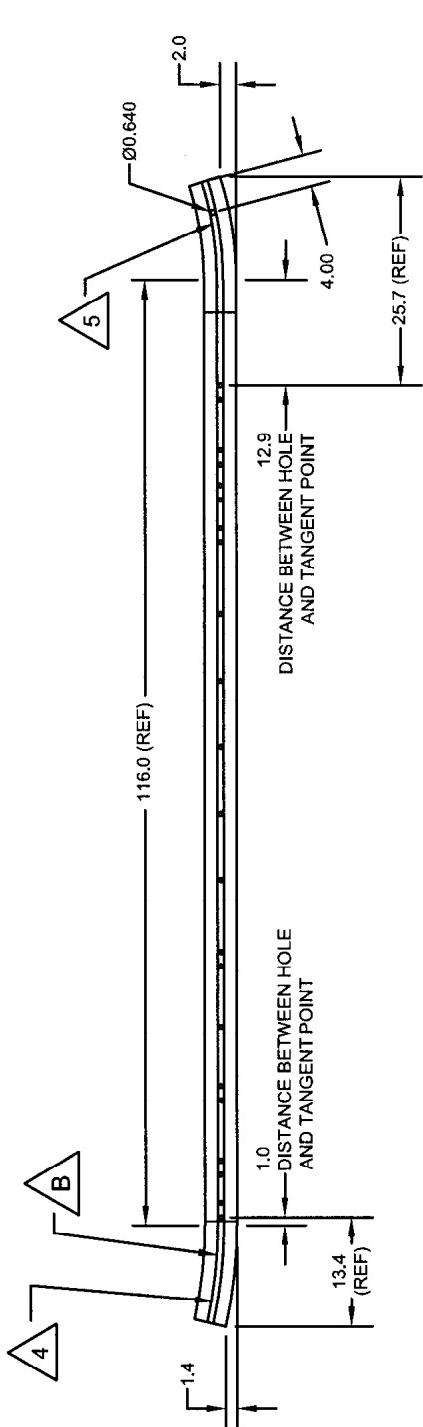
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005.4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005.4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005.4.4
- 9) INSERT D2594-1 PLUG CWN D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED
07.04.04

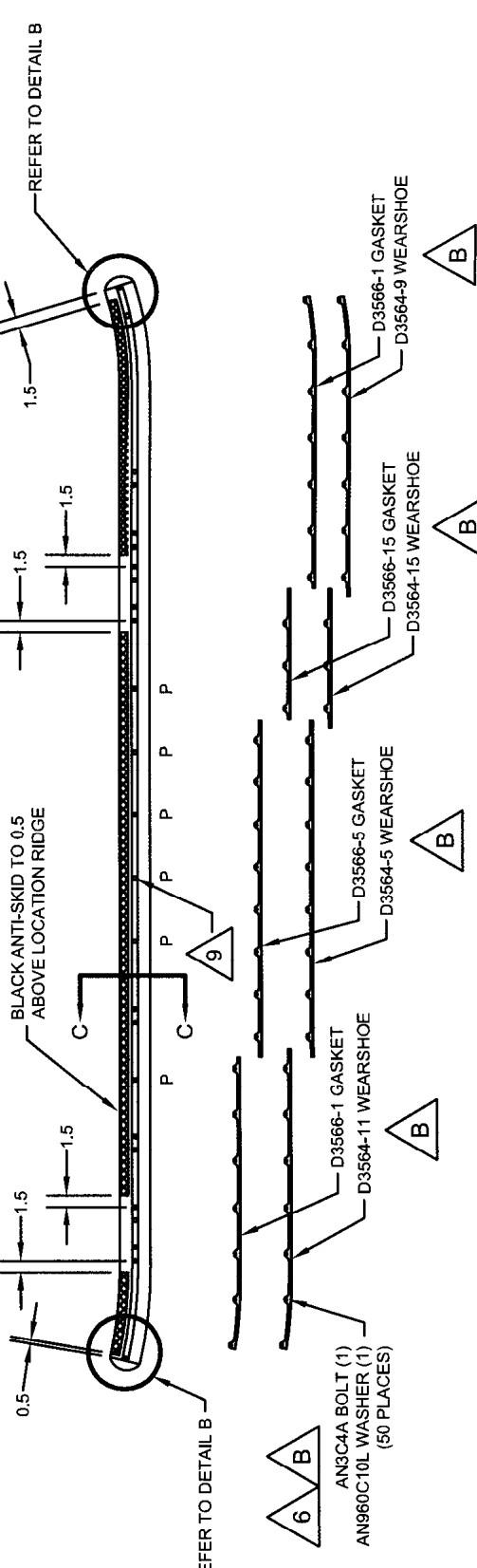
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
REV.	DESCRIPTION	BY	DATE
DESIGN	9		
DRAWN	CB		
CHECKED	AH	DRAWING NO.	REV. B
MFG. APPR.	AH	D2906	SHEET 1 OF 3
APPROVED	AH	TITLE	SCALE
DE APPR.	AH	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



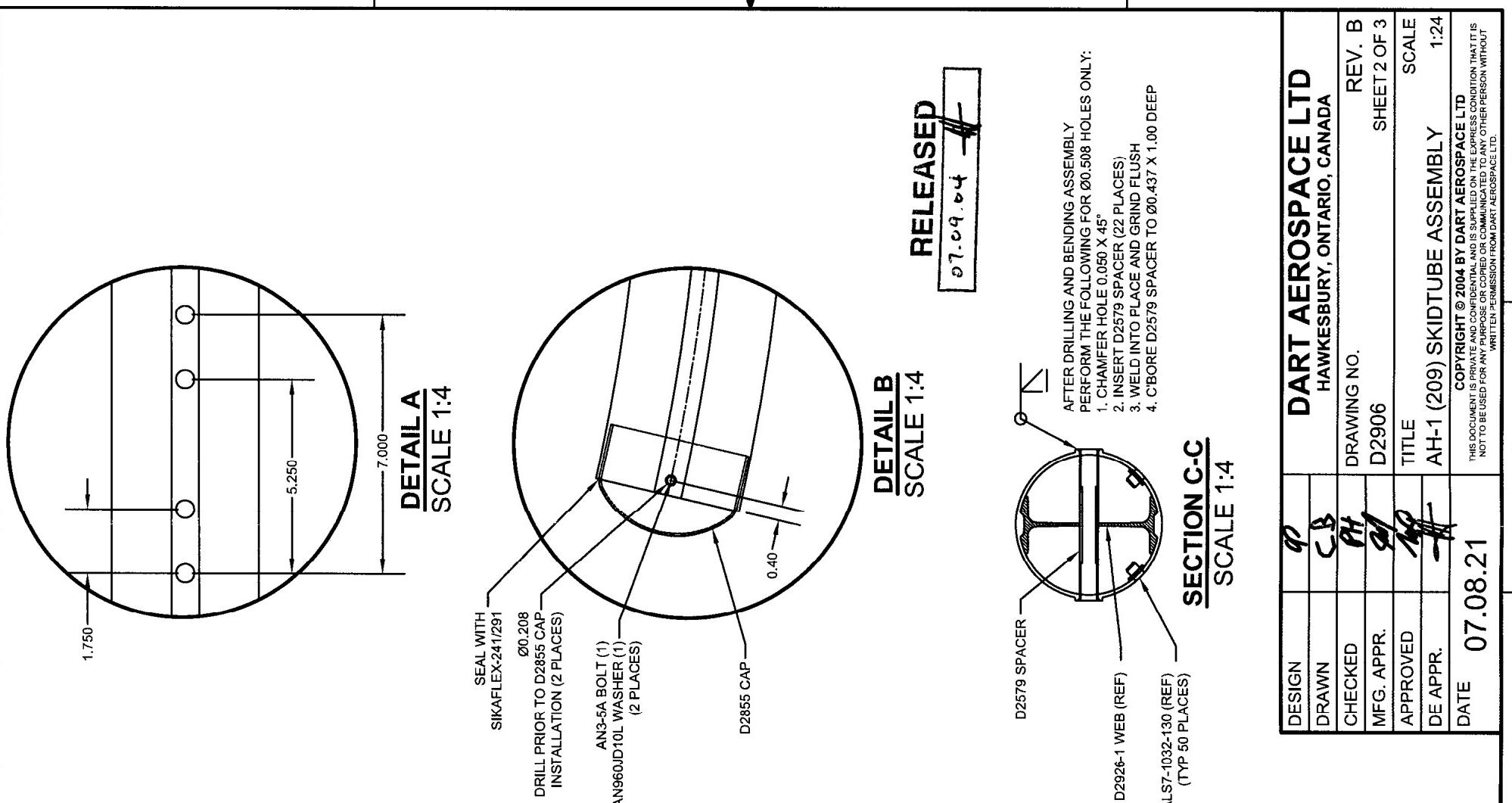
D2906-1 DRILLING DETAIL

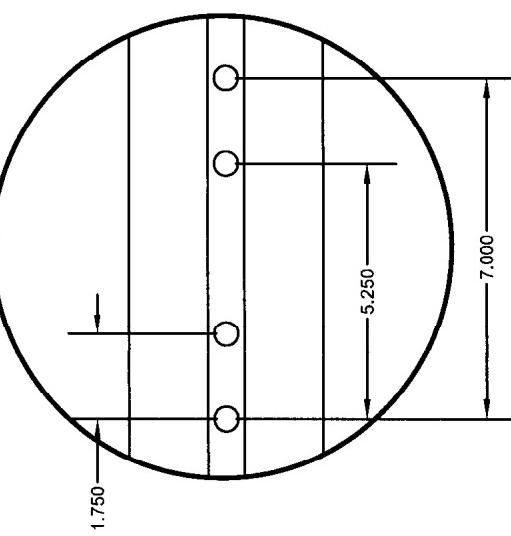


D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL





DETAIL A
SCALE 1:4

**SEAL WITH
SIKAFILEX-24/1291
DRL/PRI TO D2855 CAP
INSTALLATION (2 PLACES)
070.208**

AN3-5A BOLT (1)
AN960JD10L WASHER (1)-
(2 PLACES)

B

DETAIL B
SCALE 1:4

07.0

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

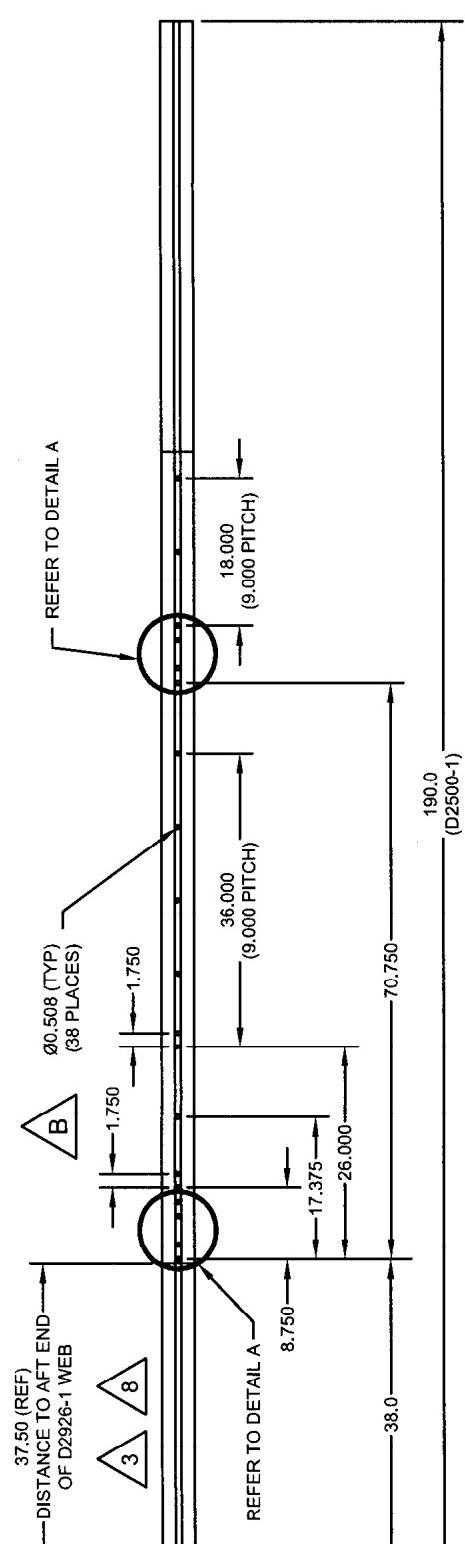
D2926-3 WEB (REF) (TYP 44 PLACES)

ALS7-1C32-130 (REF)

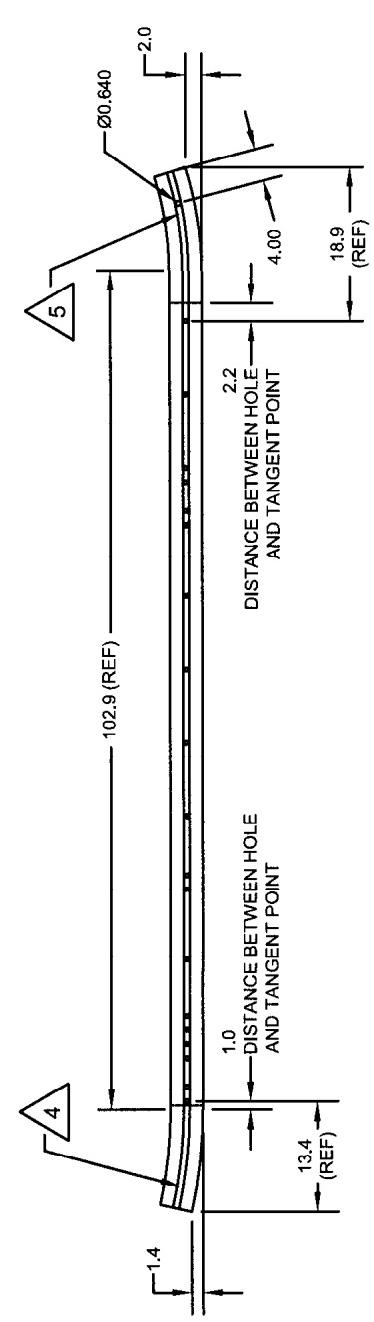
SECTION C-C

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

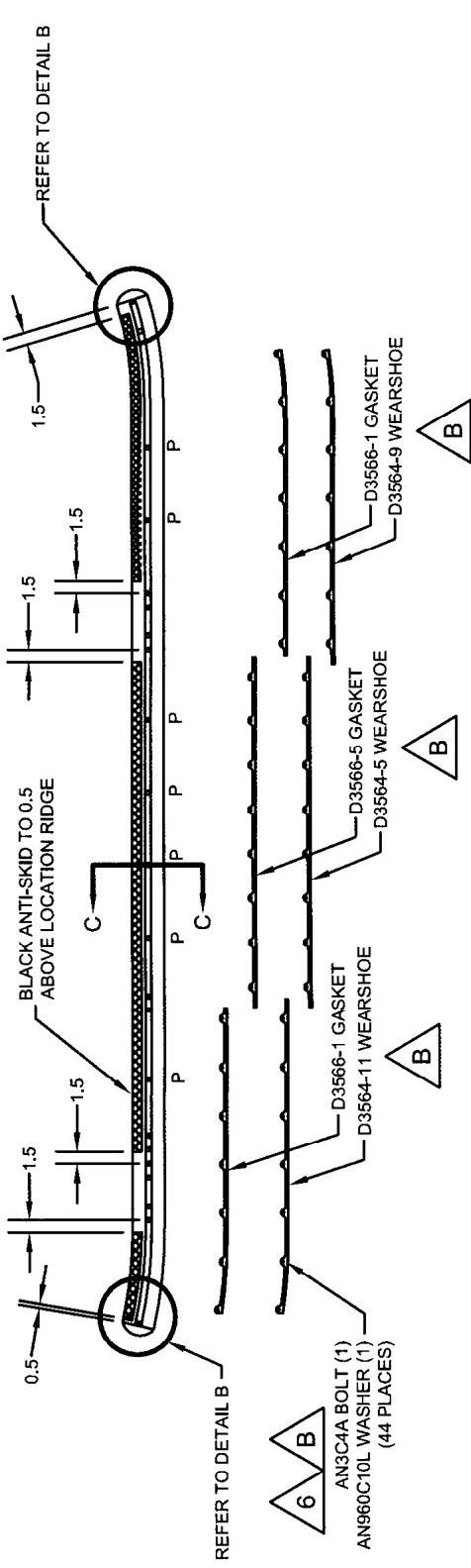
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SP</i>	D2906	SHEET 3 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>SP</i>	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			



D2906-3 DRILLING DETAIL



D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL

DRAWING NO.	TITLE	REV. B	D.E.O. NO.	SHEET NO.
D2906	AH-1 (209) SKIDTUBE ASSEMBLY		D2906-B-1	1 OF 1
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
A.P			JAD	TH
DATE	12.05.28	DATE	12.05.31	DATE
			12.05.31	12.05.31

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

QTY	QTY	PART NUMBERS	DESCRIPTION
-041	.043		
22	19	D2579	CROSS BOLT SPACER

IS

QTY	QTY	PART NUMBERS	DESCRIPTION
22	19	D4202-1	SPACER

SECTION C-C ON SHEETS 2 & 3 ARE AMENDED AS FOLLOWS FOR ALL HOLES
THAT WERE ORIGINALLY C'BORED:

RELEASED
2012-06-05
JAD

